

Date: Wednesday, 29/04/2009 7:57:53 AM  
User: Chantal Lavoie

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	3" OUTER TUBE
<b>Job Number</b> :	47575		
<b>Estimate Number</b> :	10796		
<b>P.O. Number</b> :		<b>Part Number</b> :	D26001190
<b>This Issue</b> :	29/04/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2600 REV D1
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	31032	<b>Drawing Revision</b> :	D1
	<b>Type</b> :	<b>Material</b> :	
	PURCHASED PARTS	<b>Due Date</b> :	15/05/2009
<b>Written By</b> :		<b>Qty:</b>	80
<b>Checked &amp; Approved By</b> :	<u>CL09/04/29</u>	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev.A 99.08.18 Was 2600-1 added -240 for length EC Est Rev.B 07.02.28 Changed length to -190 LL		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



**Comment:** PURCHASING

Issue P/O: 8690  
a) Extrude as per Dwg D2600 (190" long)  
b) Material: 6061-T6  
c) Bon L die # 897121  
d) Material certification is required.

CL09/04/29 (80)

2.0	D26001190P	Extrusion Round 3" 206
-----	------------	------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)  
Extrusion Round 3" 206

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
Ensure material certification is attached

CL09/05/21 (83) HM  
CL09/05/21 (83)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



**Comment:** DIMENSIONAL CHECK

CL09/05/21 (83) center  
CL09/05/21 (83)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Identify and Stock  
Location: HALL 003

CL09/05/21 (83) HM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 7:57:53 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 47575

Part Number: D26001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26/2009

Job Completion



U 09.05.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>FGP</i>	

RELEASED  
98.08.25 DS

### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

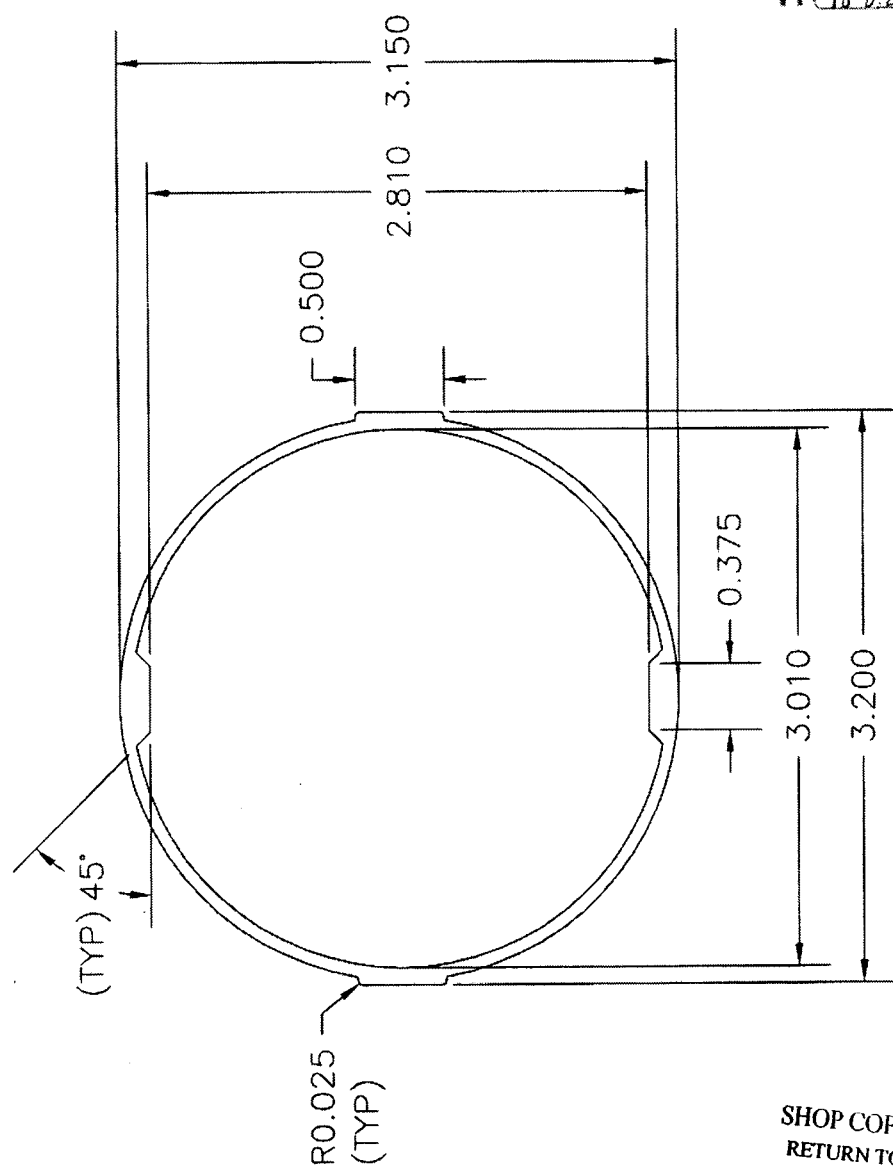
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47575



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



D2600-1

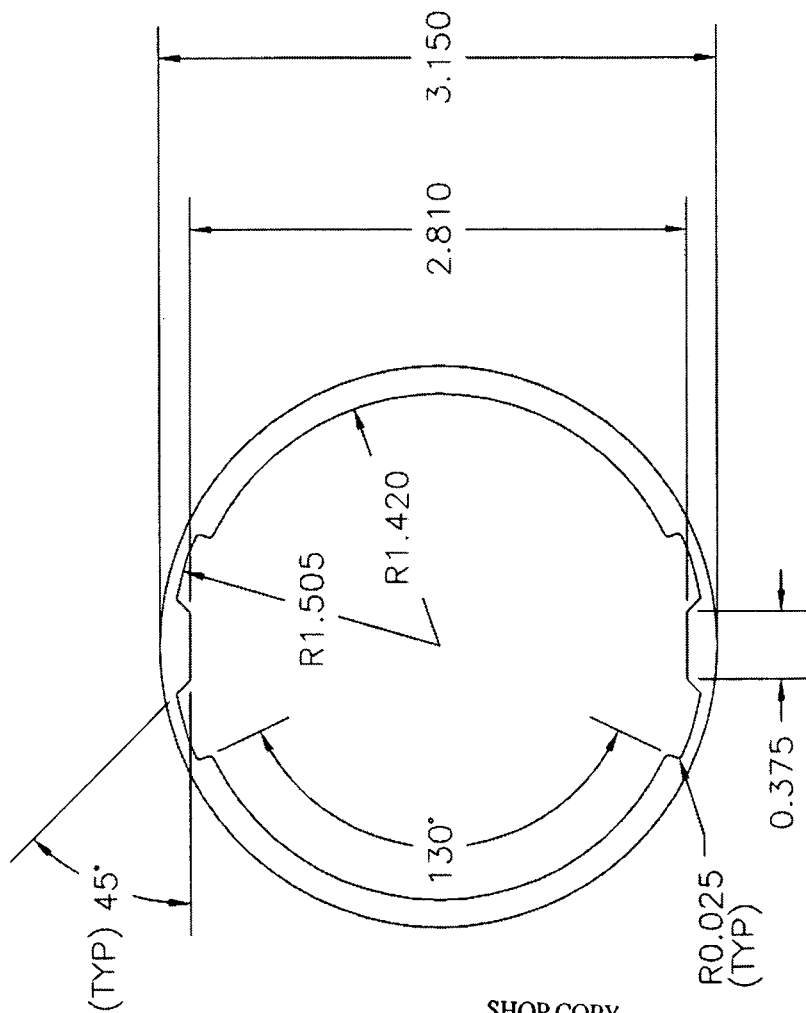
MANUFACTURED WITH CARADON INDALEX DIE # MH-18870  
OR BON L DIE # 897121 (PREFERRED CHOICE)  
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 16.0 LONG)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47575



DESIGN <i>DA</i>	DRAWN BY <i>DA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SA</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED  
98.8.25 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47575

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

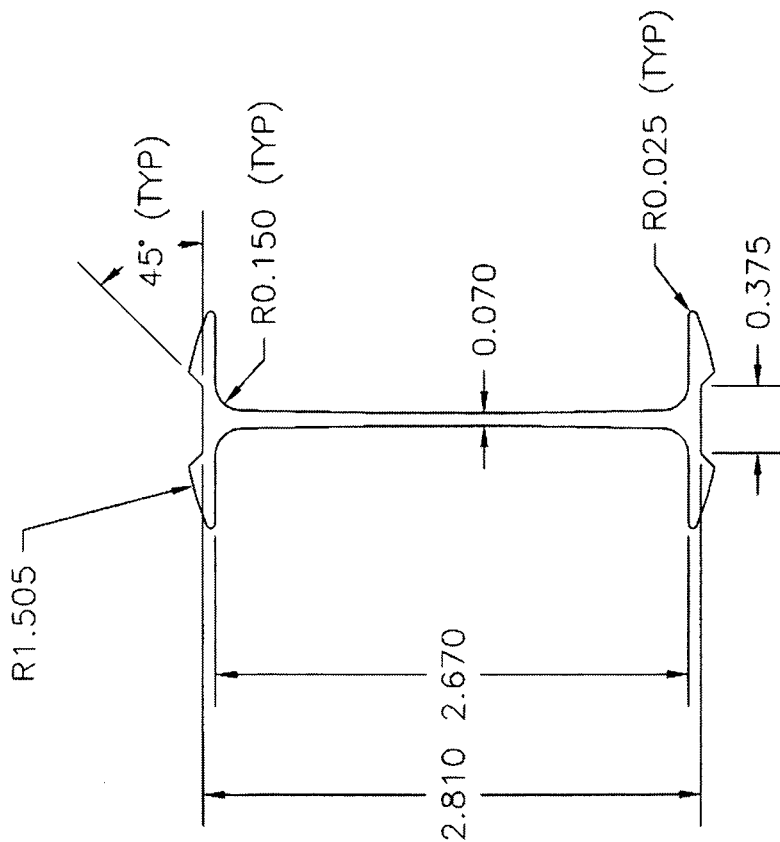
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED  
98 8 25 DS



D2600-5  
MANUFACTURED WITH CARADON INDALOX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)

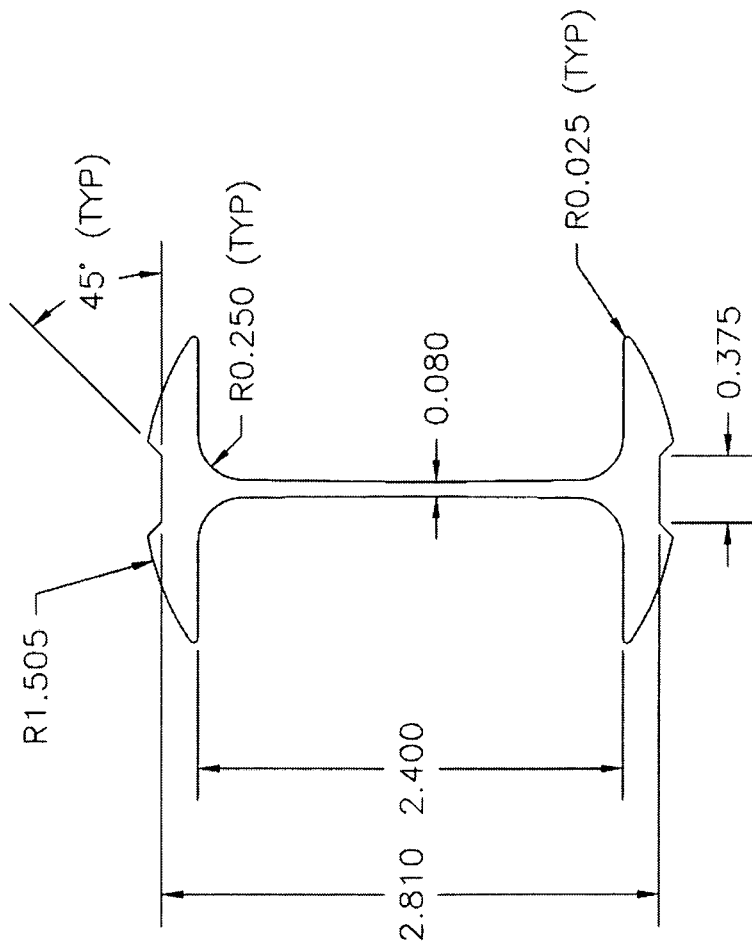


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47575



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.15 DS



D2600-7  
MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47575



AGCT# 00046024

INVOICING COMPANY AND LOCATION  
SIGNATURE ALUMINUM CANADA  
500 EDWARD AVENUE  
RICHMOND HIL ON L4C 4Y9

## SHIPPING MANIFEST

MANIFEST DATE	05-19-09
MANIFEST NUMBER	659699
SALES ORDER NUMBER	47547

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCE

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
--	--

TERMS / FREIGHT  
O / P

CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227

CUSTOMER ID 46024	ORDER DATE 04/29/09	CUSTOMER PO NUMBER 8690	JOB	BILL OF LADING NUMBER 08392726
----------------------	------------------------	----------------------------	-----	-----------------------------------

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	80	KG	0	DAA-897121-3	6061 /T6	MILL	2	592	572	KG	0
		M	0	D2600-1-190	190"	CERTIFICATE OF COMP.			400.56	M	0
		PC	0		+5/16 "	(+015-015,0092-0068)			83	PC	0
					-0 "						
					LOT/TKT DETAIL:						
						47547010 / 210278	1	167	157		23 PC
						47547010 / 210279	1	425	415		60 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

# CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

Cart. Date	Cart. No.	Sales Order	Page
05/19/09	191427	47547	1
Cust. PO	B/L No.	Lot	Date
8690	08392726	47547010	5/19/09

Sold To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-897121-3	190" Mill 6061 T6	D2600-1-190
Gross Weight	592 KGS		
Net Qty	572 KG	83 PC	401 M 2 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-08		

Mechanical Tests:												
Test No.	Tensile MPA / KSI		Yield MPA / KSI		%Elongation		Conductivity		Bend/ Drift HREW			
1	307.6 / 44.6		264.9 / 38.4		10.6		.0		90			
Chemical Analysis:												
SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.65	.26	.26	.06	.89	.04	.007	.05	.000	.010	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc

S  
05/19/09